



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-19-1

Job Sheet 176840



Part No: C3-19-1

Job Qty: 20 ea

Part Name: Lifting Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/2/18

Job Tracking No:

Due Date: 5/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C3-19-1 Rev 7 IPP Rev A 18.03.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		5/18/18	0.00	0.00	Start Up Machining-3		
110	Lathe Conv	20 pcs		5/18/18	0.00	6.67	Lathe Conv-1		
120	QC	20 pcs		5/18/18	0.00	0.00	QC2 Machining-4		
130	QC	20 pcs		5/18/18	0.00	0.00	QC8 Machining-4		
150	Outsource	20 pcs		5/18/18			GRO002-VC	10	
160	Packaging	20 pcs		5/18/18	0.00	0.00	Packaging2		
170	QC	20 pcs		5/18/18	0.00	0.00	QC6		
180	Packaging	20 pcs		5/18/18	0.00	0.00	Packaging3-1		
190	QC21-SA	20 Ea		5/18/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG 2-Deburr

Descriptions: 150 - -Issue P/O to Groupe Altech: P/O 039965 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91257A833	Hex Head Screw	20 pcs (1 ea)	90-Start up Operation	S058791

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91257A833	20	20	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 5/2/18 8:20 AM Dart.lajeunesse.marie

Container No: S072581



Part: C3-19-1

Job No: 176840

Serial No/Batch: S072581

Revision: 7

Inspector:

Date: 05/18/18

BQA:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

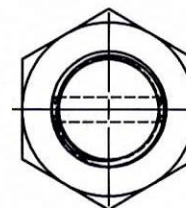
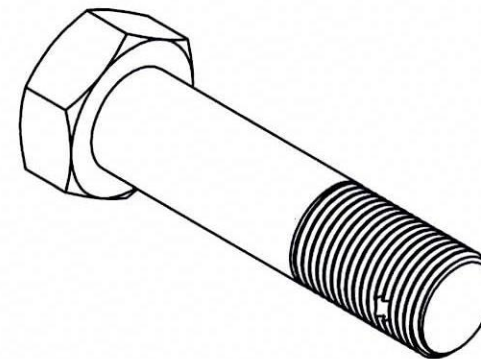
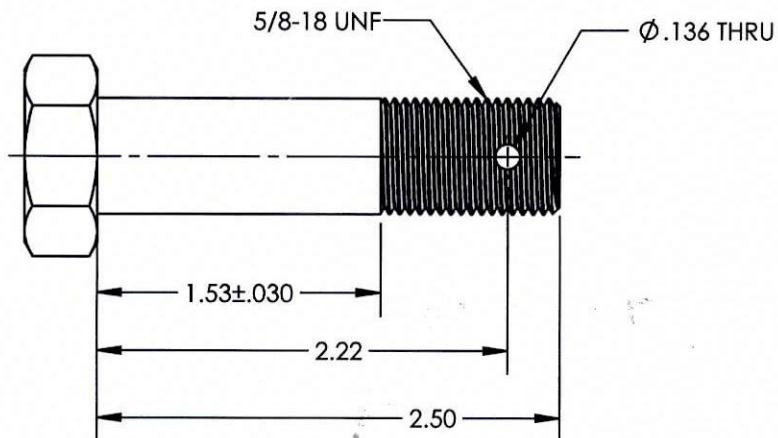
Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : 32					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	15-0252	UPDATED TO NEW DRAFTING STANDARDS. ADDED FINISH CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II.	8/27/2015	DPD	JAG
7	16-0228	CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2.	11/21/2016	DPD	JAG



DART AEROSPACE	
TITLE LIFTING BOLT C3 CAGE	
DWG NO. C3-19-1	REV 7
MAT'L STEEL HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CANAM CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL	
SCALE 1:1	DATE
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-19-1	1	LIFTING BOLT	STEEL	5/8-18 X 5, GRADE 8 (MCMaster-CARR #91257A833) MODIFIED

930 12/10/30 430 690 800



Traveller Change Request

Part#: C3-19-1

Job#: 176840

Name: Jonathan Villeneuve

Date: 18/5/17

Workcenter: Machining Conventional

Operation #: QC2 and Mill Conv.

Issue: Quality ☐

Wrong Routing ☒

Op Description ☐

~~Missing Information ☒~~

Material ☐

Other ☐

Change requested: Add Mill.Conv. after QC2 and add a QC2 after Mill Conv.

Name: _____

Date: _____

Workcenter: _____

Operation #: _____

Issue: Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Name: _____

Date: _____

Workcenter: _____

Operation #: _____

Issue: Quality ☐

Wrong Routing ☐

Op Description ☐

Missing Information ☐

Material ☐

Other ☐

Change requested: _____



Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200

PURCHASE ORDER **PO039965**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039965
PO Date: 5/23/18
Due Date: 5/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173867	RBE350A93-3500-00-1	Body -Issue P/O to Groupe Altech: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	5/29/18	12 pcs	0 pcs	12 pcs	\$1.95/pcs	\$23.40
2	176840	C3-19-1	Lifting Bolt -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	5/29/18	20 pcs	0 pcs	20 pcs	\$1.50/pcs	\$30.00
3	177272	RBW6305G11331-3G-13	Socket -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	5/29/18	1 pcs	0 pcs	1 pcs	\$1.85/pcs	\$1.85
4	177405	C250-100	Side Plate Cover -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	5/29/18	3 pcs	0 pcs	3 pcs	\$58.50/pcs	\$175.50

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9-89



Certificat de Conformité / Certificate of Compliance

(009663-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009663- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
29-May-2018		Jessie Boisvert		PO039965				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	C3-19-1 Rev.	C3-19-1 TYPE 2 SC2 0.00030 1 - ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours	ZINC CH	20	20	0	0	0

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MAY 29 2018

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.